Work Order ID 67209

Thursday, March 10, 2011 12:31:21 PM

ASAP

Item ID: D2562-013 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Strut

Start Date: 3/10/2011 **Start Qty:** 5.00 **Cust Item ID:**

Required Date: 3/18/2011 **Req'd Qty:** 5.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** 11-03-10 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2562	Rev D								
100		0.00				5X			
Brake NC	NC BRAKE								
Brake NC	**Memo** Punch to length as per Dwg D2562	0.00							
		7m-l 11/03/11							
110		0.00				5X			
Small Fab	Small Fab								
Small Fab	**Memo** 1- Bend end as per Dwg D2562 Angle "D"□2- Deburr	0.00							
		7m-l 11/03/11							
120	QC5- Inspect part completeness to step on W/O	0.00							
QC									
Quality Control	**Memo**	0.00 E 11/03/11				X			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector.

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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Run Start

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Stop

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat	M115951					5	BR	11-3-14	
	Memo	0.00							
Powder Coating	START TIME: 12:00 ☐OVEN TEMPERATURE: 400° ☐FINISH TIME: 12:30.								
140	QC3- Inspect Part Finish	0.00							
QC						5	ϕ	11/03/15	
	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: 264	0.00							
Packaging						11/3/15			
	Memo	0.00							
Packaging									

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00						11/3/16	
Quality Control									

MF
11-03-16

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Thursday, March 10, 2011 12:31:27 PM

Work Order ID: 67209

Parent Item: D2562-013

Parent Item Name: Strut

Start Date: 3/10/2011 **Required Date:** 3/18/2011

Start Qty: 5.00 **Required Qty:** 5.00

Comments: IPP □A□05.05.18□New Issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035 304 RD Tube .500 x .035W		Purchased	No			100	f	88.0147	2.2916	12.06105			

~~m-f 11/03/11~~

Location	Loc Qty	Loc Code
MAT	88.01469535	
115593	9.080387	
115990	34.4846264	
116720 ✓	44.449682	

~~12-06105~~

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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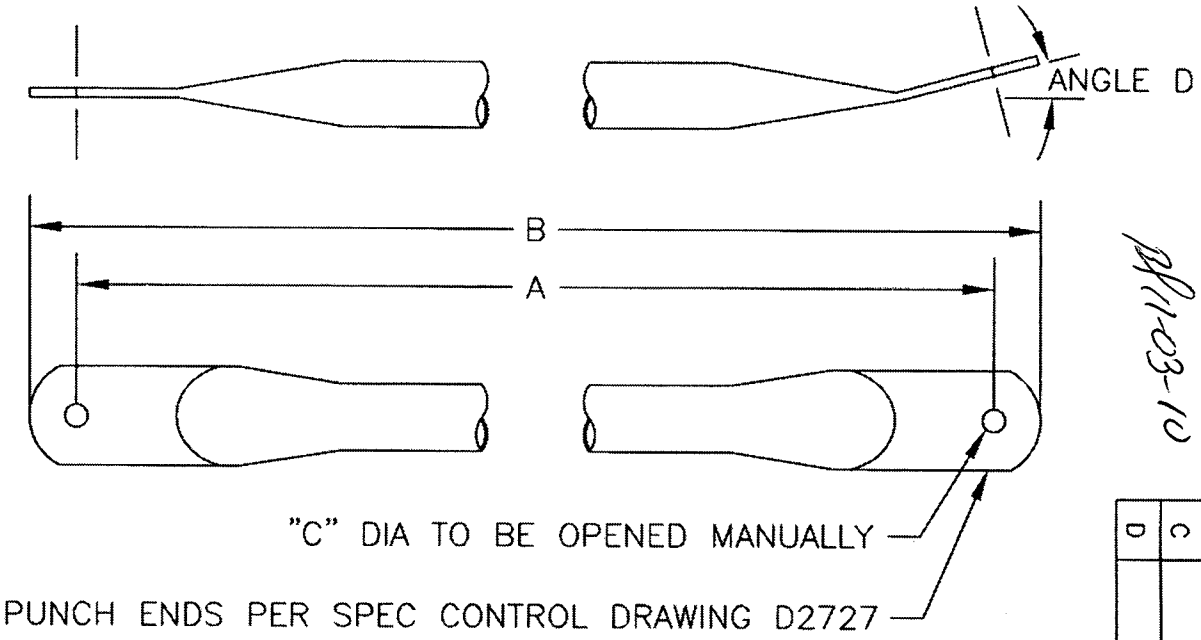
DESIGN	DRAWN BY	DART AEROSPACE LTD	
CP	RF	HAWKESBURY, ONTARIO, CANADA	REV. D
CHECKED	APPROVED	DRAWING NO. D2562	SHEET 1 OF 1
DATE 05.05.18		TITLE STRUT	SCALE 1:2

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62209



A	96.05.01	NEW ISSUE
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)
C	02.06.05	ADD -005; ADD FINISH
D	05.05.18	ADD -007/-011/-013; UPDATE -005

RELEASED
05-05-27

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	–	10
D2562-003	20.37	21.17	–	18
D2562-005	29.00	29.80	–	30
D2562-007	19.22	20.02	–	0
D2562-011	25.79	26.59	–	16
D2562-013	26.63	27.43	–	24

GENERAL NOTES
1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035)
ENSURE SEAMLESS TUBE IS USED
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

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